













Date: Thursday, 02/04/2009 2:25:02 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FRAME
Job Number : 46827	
Estimate Number : 13827	
P.O. Number :	Part Number : D225217
This Issue : 02/04/2009 S.O. No. :	Drawing Number : D2252 REV G
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision : G
Previous Run :	Material :
Written By :	Due Date : 14/04/2009 Qty: 4 Um: Each
Checked & Approved By : <u>JUD 09-04-02</u>	
Comment : Est Rev:A 09.03.18 New Issue EC verified by:DD	
Additional Product	
Job Number: 	
Seq. #:	Machine Or Operation: Description :
✓ 1.0	M304TS0750W065 304 SQ Tube .75x.75x.065W
	 Scrap 1.5 (Fs) 
Comment: Qty.: 1.7220 f(s)/Unit Total : 6.8880 f(s) 304 SQ Tube .75x.75x.065W batch: <u>M111148</u> <u>SAD 09-04-07</u>	
2.0	LARGE FAB 1 LARGE FABRICATION RESOURCE 1
	 
Comment: LARGE FABRICATION RESOURCE 1 1- Cut as per dwg D2252 *****angle is 53***** 2- Deburr and remove identification markings on tube <u>SAD 09-04-07</u> (4)	
3.0	QC5 INSPECT WORK TO CURRENT STEP
	 
Comment: INSPECT WORK TO CURRENT STEP <u>SAD 09-04-07</u> (4)	
4.0	PACKAGING 1 PACKAGING RESOURCE #1
	 
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>WA</u> <u>SAD 09-04-07</u> (4)	
5.0	QC21 FINAL INSPECTION/W/O RELEASE
	 
Comment: FINAL INSPECTION/W/O RELEASE <u>09/04/08</u> (4)	
Job Completion	 <u>CNF 09-04-08</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	QTY -043	PART NUMBER	DESCRIPTION
1	X		D2252-041	BASKET ASSEMBLY
3		X	D2252-043	LID ASSEMBLY
7	2	2	D2221-1	RIB
8	5		D2235-1	RIB
9	2	2	D2252-1	FRAME
10		2	D2252-7	FRAME
11	1		D2252-9	FRAME
12	1		D2252-11	FRAME
13	1		D2252-13	FRAME
14	1		D2252-15	FRAME
15	4		D2252-17	FRAME
16		1	D2252-23	FRAME
17	2		D2253-1	LUG
18	2		D2254	GUSSET
19	1	1	D2327-3	BUSHING
20		1	D2329	LABEL PLATE
21	4	2	D2581	MOUNTING CHANNEL
22		2	D2989-19	RIB
23	3		D3748-1	HINGE HALF
24		3	D3749-1	HINGE HALF

RELEASED
9/02/18

NOTES:

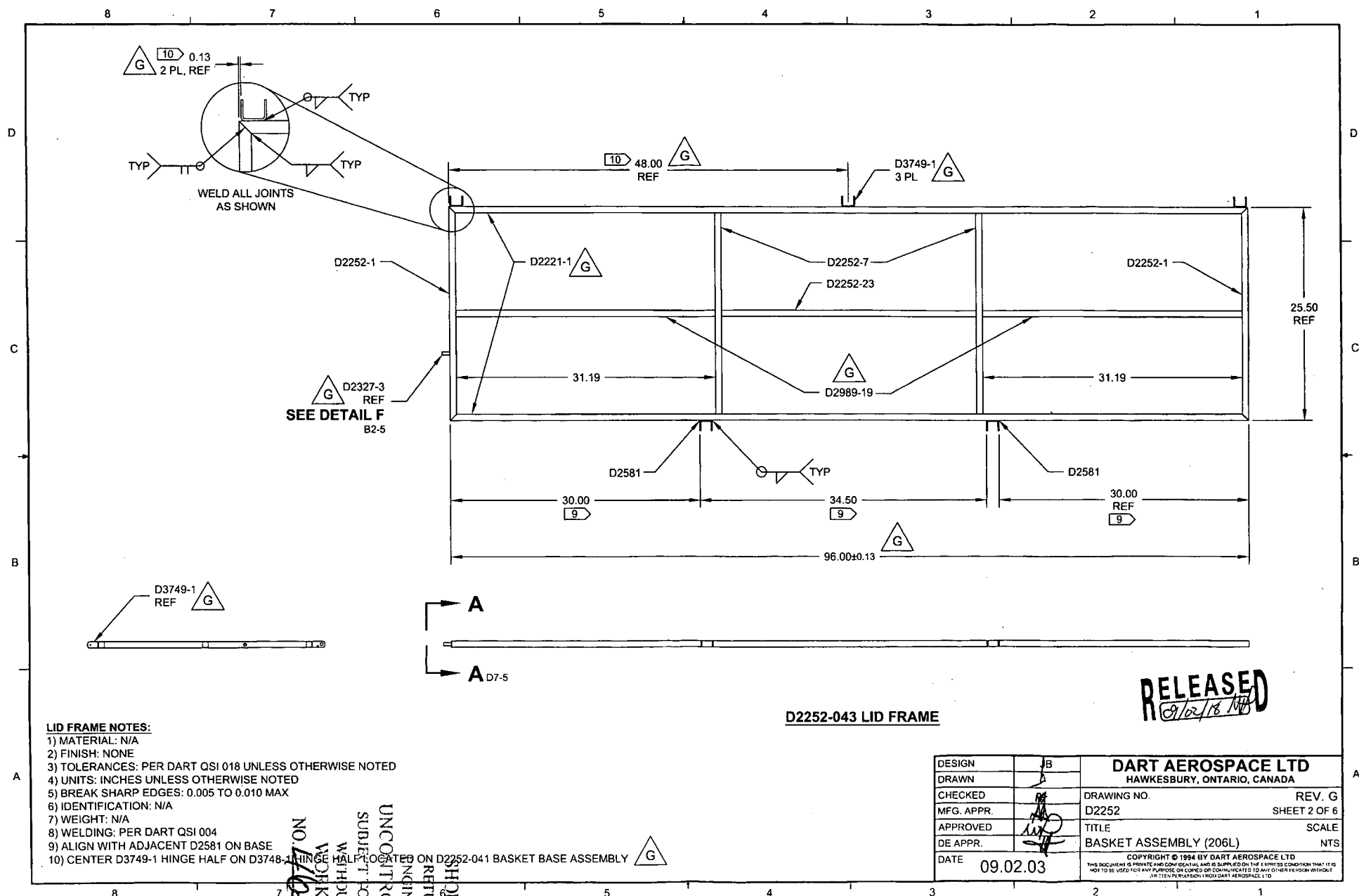
- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
- 3) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A
- 8) WEIGHT: N/A
- 9) WELDING: PER DART QSI 004

WORK ORDER
11082271

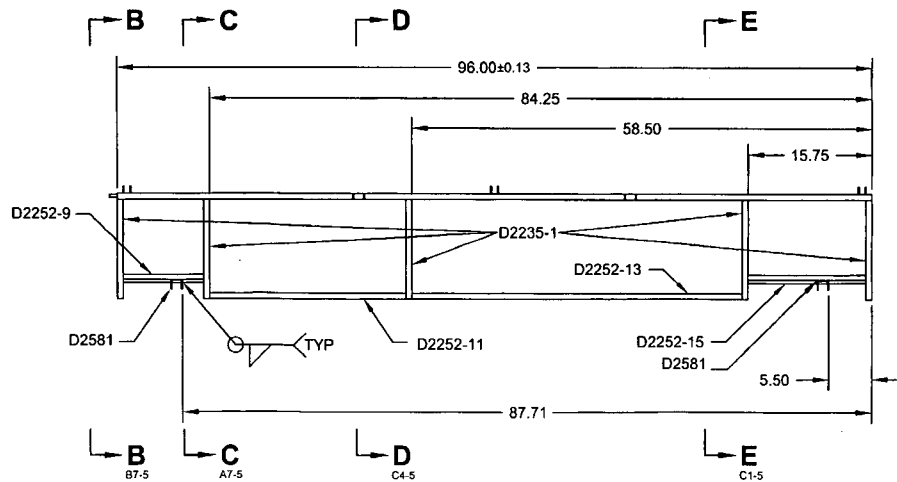
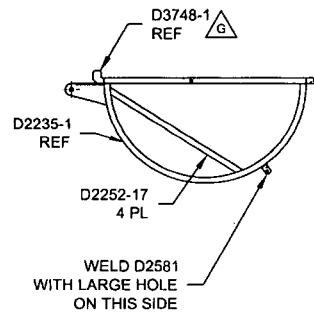
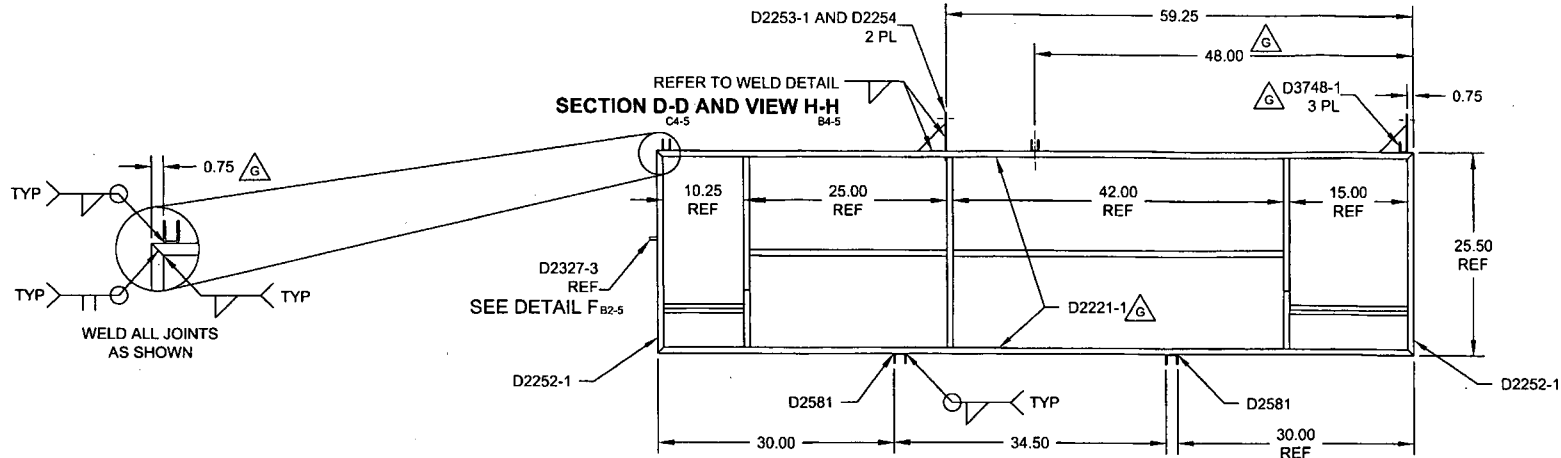
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

ENGINEERING
RETURN TO
SHOP COPY

G	ADDED 'ITEM' COLUMN TO PARTS LIST; ADDED NOTE 10 ON SHT 2; ITEMS 23 AND 24 REPLACE D2232-1/-3; STRETCHED LID FROM 95.27" TO 96.00"; ITEM 7 REPLACES D2252-3/-19; ITEM 19 (ON LID) REPLACES D2327-1; ITEM 22 REPLACES D2252-21; UPDATED TOOLING (ZN A6-5). P/N REASON: SEE PAR#09-006.	MB	09.02.03
F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. SHT 2 VIEWS INVERTED FOR CLARITY. FRAME MATERIAL THICKNESS WAS 0.060.	AJS	08.08.11
E	INCORPORATED D1 & D2. ADDED D2231-1/-3 & D2252-19.	MB	05.11.10
D	MODIFIED LATCH, D2581 WAS D2255-3	BK	99.09.14
C	RE-DRAWN	BK	95.12.11
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2252	SHEET 1 OF 6
APPROVED		TITLE	SCALE
DE APPR.		BASKET ASSEMBLY (206L)	NTS
DATE	09.02.03	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OTHER THAN THAT FOR WHICH IT WAS SPECIFICALLY SUPPLIED WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	



UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
NO. 140807
WORK ORDER
7



D2252-041 BASE FRAME ASSEMBLY

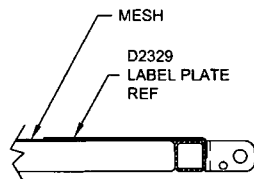
RELEASED
01/02/16

BASE FRAME NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELDING: PER DART QSI 004

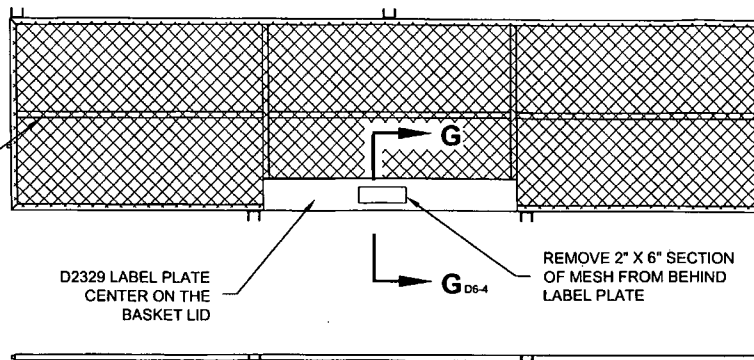
WORK ORDER
 1168827
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 ENGINEERING
 RETURN TO
 SHOP COPY

DESIGN	UB	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2252	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		BASKET ASSEMBLY (206L)	NTS
DATE	09.02.03	COPYRIGHT © 1994 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT A WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

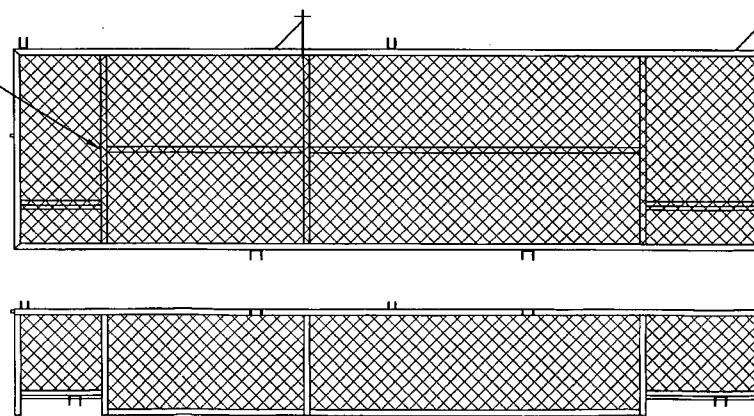


SECTION G-G
ROTATED 90° CCW

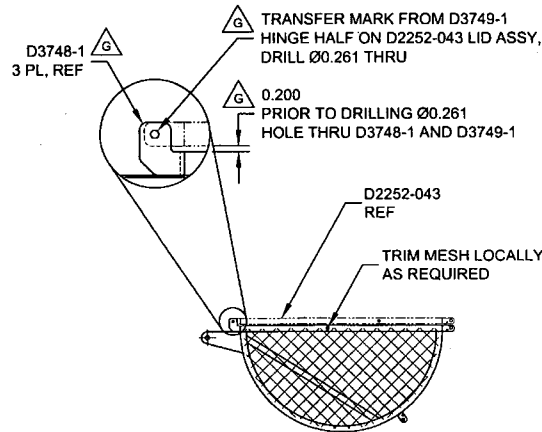
TACK WELD EACH
STRAND END OF
STEEL MESH TO FRAME



D2252-043 LID ASSEMBLY



D2252-041 BASE ASSEMBLY



ASSEMBLY NOTES:

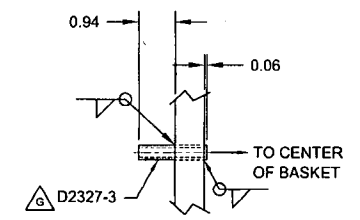
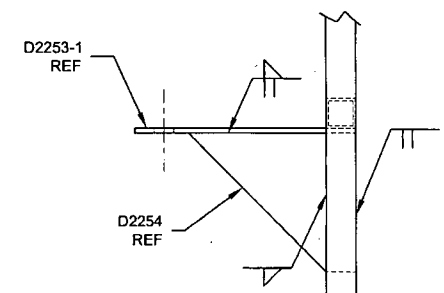
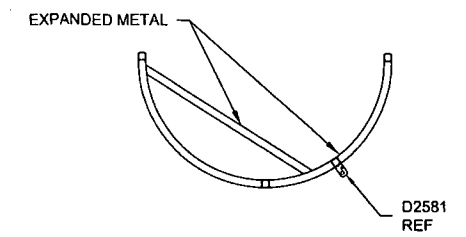
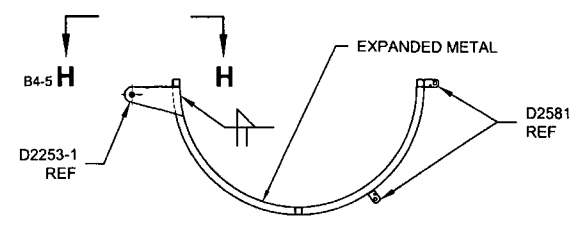
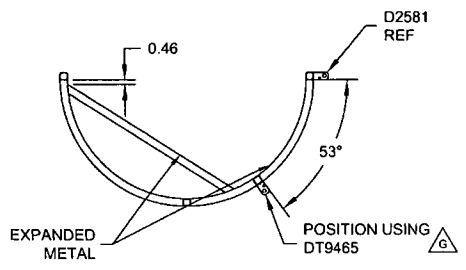
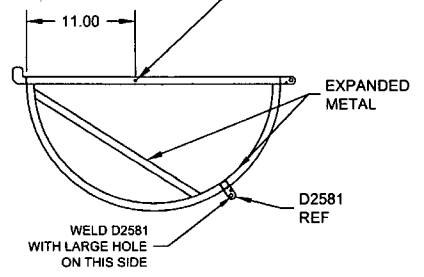
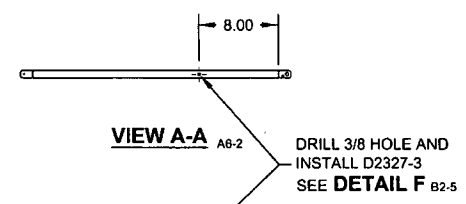
- 1) MATERIAL: SEE SHEET 1 FOR MESH MATERIAL
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELDING: PER DART QSI 004

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 128827

DESIGN	JB	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2252	SHEET 4 OF 6
APPROVED		TITLE	SCALE
DE APPR.		BASKET ASSEMBLY (206L)	NTS
DATE	09.02.03	COPYRIGHT © 1994 BY DART AEROSPACE LTD	

RELEASED
09/02/03

8 7 6 5 4 3 2 1



DETAIL F C5-3
SPACER INSTALLATION C6-2

RELEASED
09/02/03

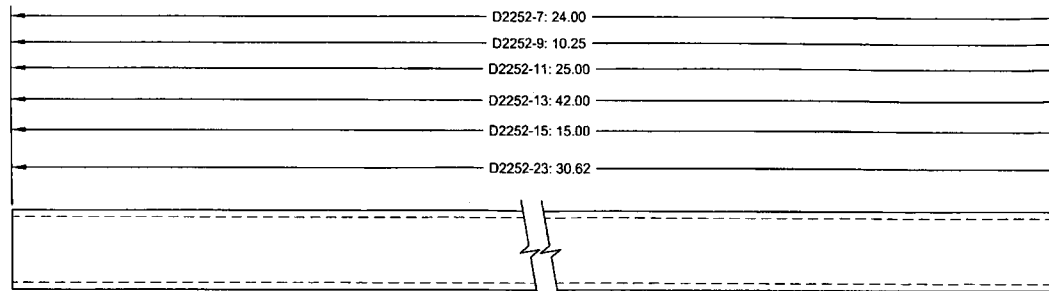
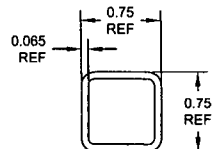
NO. 40827
WORK ORDER
WITHOUT NOTICE
SUBJECT TO AMENDMENT
CONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

DESIGN	JB	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2252	SHEET 5 OF 6
APPROVED		TITLE	SCALE
DE APPR.		BASKET ASSEMBLY (206L)	NTS
DATE	09.02.03	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

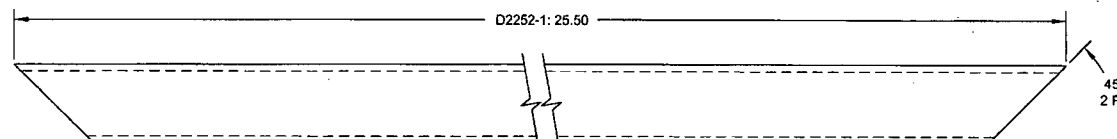
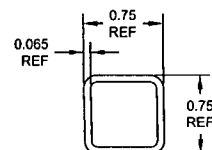
8 7 6 5 4 3 2 1

D



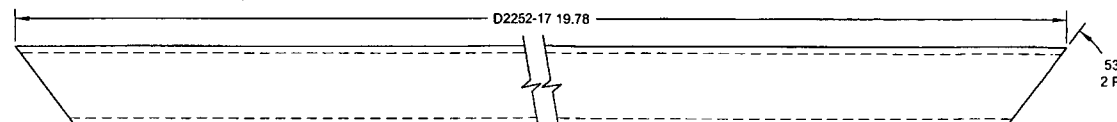
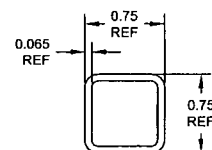
D2252-7 FRAME
D2252-9 FRAME
D2252-11 FRAME
D2252-13 FRAME
D2252-15 FRAME
D2252-23 FRAME

C



D2252-1 FRAME

B



D2252-17 FRAME

A

- NOTES:**
 1) FRAME MATERIAL: SEE SHEET 1
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: N/A

WORK ORDER
 040827
 WITHOUT NOTICE
 SUBJECT TO AMENDMENT
 UNCONTROLLED COPY
 ENGINEERING
 RETURN TO
 SHOP COPY

RELEASED
 01/04/04

DESIGN	JB	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D2252	REV. G
MFG. APPR.			SHEET 8 OF 6
APPROVED		TITLE	SCALE
DE APPR.		BASKET ASSEMBLY (206L)	NTS
DATE	09.02.03	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS COVENANT THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1